

Order ID 56276

Wednesday, February 17, 2010 1:13:30 PM



Page 1

Item ID: D350-636-013

Accept

Revision ID:

Item Name: Skidtube LH

Start Date: 2/18/2010 Start Qty: 1.00

Required Date: 3/5/2010 Req'd Qty: 1.00

Reference:



Setup Start

Stop

Cust Item ID:

Customer:

Approvals: Process Plan: *mf*

Date: *10-2-17* Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2750

Rev F

100



DC

Document Control

DOCUMENT CONTROL

Memo

Photocopy blue file and type labels per PPP D350-636-013 CHG 005

0.00

0.00

sd

8/10/03/16

HJ for BG 10/03/16


56276

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

 Date & initial all entries

Work Order ID 56276

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Page 2

Item ID: D350-636-013

Accept



Setup Start



Revision ID:

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Stop



Start Date: 2/18/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 3/5/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

H10



Skidtubes

Skidtubes

0.00

Memo

0.00

Skidtubes

1- Mark cut line on aft end of D2600-3-Bent using Jig DT 8150. Cut to length as per Dwg D2750. Deburr end

2-Drill pilot holes as per Dwg D2750 sheet 6 (D2750-3 details). Drill using drill Jig DT8150 & DT8864.

3- Mark fwd end for cutting using Drill Jig DT 8150 & DT8864 and cut as per dwg D2750.

4-Drill pilot holes for the blade fitting bolt holes using DT8983. Open to 0.500".

5- locate DT8330 off of blade fitting bolt holes and drill pilot holes for blade fitting.

6-Open up holes for SECTION AW-AW to 0.375" (2 holes per side) and blade fitting location holes to 0.500" (total of 4 holes per side) as per dwg D2750. Open holes for ground handling and detail T to 0.500" (8 holes per side)

7-Drill pilot holes for wearplates as per Dwg D2750 using DT8108 and open to 0.297"

8-Open up holes of Detail S to 0.297" (total of 2 holes per side)

9-Weld D2744 Cap as per Dwg D2750 and QSI 004. Fill grooves in bend left from bending as per QSI 004

A/R ☐ Aluminum Rod

M113207 BE 10/02/22

12-Grind welds flush as per Dwg D2750

H10/21/22

H10/2/22

Pb-7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D350-636-013 PAR #: _____ Fault Category: Skid tubes NCR: Yes No DQA: _____ Date: 10/03/29
 Resolution: re-work Disposition: re-work QA: N/C Closed: _____ Date: 10/03/30

NCR: <u>56276</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
10/2/22	110.3	Find skid holes on near the Prod COP (Section A) were drilled at center, on 1 side only. R.L. Sig was followed the contour of the Prod / process → tolerance stack-up.	<i>[Signature]</i>	Fill in holes to with weld to per Q7-004. A/c# <u>M113207</u> grind weld fluid. - B. Align holes by hand and redrill	BE 10-02-22 H 10/2/22	S 10/02/22 10/02/22	<i>[Signature]</i>	S 10/02/22
								S 10/02/22

NOTE: Date & initial all entries

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Setup Start

Stop



Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

13- scribe batch #.

11/12/22

120



QC

Quality Control

QC10- Inspect visual per QSI004- ground welds

0.00

8/10/12/22

Memo

0.00

130



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

8/10/12/22

Memo

0.00



140



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

Memo

0.00

11/12/23

W/O:		WORK ORDER CHANGES					
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Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

QC3- Inspect Part Finish

0.00

QC

Memo

0.00

Quality Control

x/1

BE 10/02/23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Item ID: D350-636-013

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Setup Start



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Stop



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Required Date: 3/5/2010 Req'd Qty: 1.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160



Skidtubes

Skidtubes

0.00

Memo

0.00

1-Open up holes section AW-AW 0.500" (4 per side) as per dwg D2750

2- Open holes section AV-AV 0.3125" (4 per side)

3-Open up holes of Detail T and ground handling to 0.625" (total of 8 holes per side) as per dwg D2750.

4-Chamfer holes of section AW-AW, AV-AV, T and ground handling. (welding instructions on sheet 10)

5-Deburr and blow out all chips from inside of tube. Prepare tube for welding, remove alodine as required.

6-Bond web D2739 in place as per QSI 015

A/R ☐ Sikaflex-291

batch: M12429

exp. date: 12/31/30

7- Weld spacers D3490-1, D3490-5 and D2743 as per dwg D2750 & QSI004 (welding instructions on sheet 10)

A/R ☐ Aluminum Rod

batch: M13207

BE 10/02/24

8-Grind welds flush as per Dwg D2750

9-Spot face ground handling holes (total of 4 places per side) as per dwg D2750

10-Deburr holes

M12/2/23

AWM 10-2-25

W/O:		WORK ORDER CHANGES					
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Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

170



QC

Quality Control

QC10- Inspect visual per QSI004- ground welds

0.00

8.10/26

Memo

0.00

180



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

8.10/26

Memo

0.00

(10)

190



HandFinish

Hand Finishing

Pressure Wash per QSI005 4.3

Free line as per PAR09-043

Memo

0.00

7.10 10/03/09

0.00

(X1)

Ø

W/O:		WORK ORDER CHANGES					
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Reference:

Accept

Setup Start

Stop

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

200



Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

Memo

START TIME: 1:45pm

OVEN TEMPERATURE: 320°F

FINISH TIME: 2:15pm

0.00

0.00

⇒ ML 10/03/09

ⓧ

210



QC

Quality Control

QC3- Inspect Part Finish

Memo

Inspect for foreign object per QSI 024

0.00

0.00

BR 10-3-11

ⓧ

220



HandFinish

Hand Finishing

HandFinishing

Memo

1-Install inserts as per dwg D2750

0.00

0.00

BR 10-3-11

ⓧ

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Accept



Setup Start

Stop

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

230



HandFinish

Hand Finishing

HandFinishing

0.00

Memo

0.00

1-Inspect for Foreign Objects

2-Spray inside of tube with "LPS-3" batch:

3-Install blade fitting D3488-041, wearshoes and ground handling hardware as
per dwg D2750

SIKA FLEX 241

BATCH: 1012345

EXP DATE: 10/08

4-assemble o-ring to plug as per dwg D3492 and apply o-ring lube

A/R 55-o-ring lube batch: 101233

5-Coat all exposed fasteners with "LPS Procyon" batch: 104251

QC5- Inspect part completeness to step on W/O

0.00

240



QC

Quality Control

Memo

0.00

L 8 don't

BR 10-B-11. ①

ⓧ f

W/O:		WORK ORDER CHANGES					
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Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

250

Pick Kit

0.00

Packaging

Memo

0.00

Packaging

10-3-12 *sl*

260

QC4- 100% Inspect kits for completeness

0.00

QC

Memo

0.00

Quality Control

8/10/16

40

270

Packaging

0.00

Packaging

Memo

0.00

Packaging

Package as per PPP D350-636-013

*hnp**Rec'd 2/18/10*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Work Order ID 56276

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Setup Start



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Cust Item ID:

Required Date: 3/5/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

280

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/03/24 JF

10/03/08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

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Page 1

Work Order ID: 56276

Parent Item: D350-636-013

Parent Item Name: Skidtube LH

Comments: IPP Rev:H 02.09.25 Rearranged procedure steps KJ
 IPP rev I 06.03.30 Per rev. D dwg EC
 IPP Rev:J 07-07-28 Added SS Wearplates(Rev E) JLM Verified By:EC
 IPP Rev:K 08-09-23 revF as per dwg DD verified by:ec

Start Date: 2/18/2010

Required Date: 3/5/2010

Start Qty: 1.00

Required Qty: 1.00

D2600-3-BENT

Manufactured

No

110

Each

11.0000

1.0000



Extrusion Bent

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

LG

9

50675

2

55462

7

Main Warehouse

ST

2

43495

1

47133

1

D3493-1

Manufactured

No

110

Each

37.0000

2.0000



Washer

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

37

44902

2

47710

35

11012122

10-3-12

2

W/O:		WORK ORDER CHANGES					
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 IPP Rev:K 08-09-23 revF as per dwg DD verified by:ec

Start Date: 2/18/2010

Required Date: 3/5/2010

Start Qty: 1.00

Required Qty: 1.00

D2739 Manufactured No 160 Each 6.0000 1.0000
 350 I Beam

Warehouse	Location	Loc Qty	Loc Code
Main Warehouse	ST	6	
	47124	1	
	55569	1	
	55986	4	

D2744 Manufactured No 160 Each 45.0000 1.0000
 Cap

Warehouse	Location	Loc Qty	Loc Code
Main Warehouse	ST	45	
	44892	1	
	47488	22	
	51922	22	

11/21/23

1 BE 10/02/22

Wednesday, February 17, 2010 1:13:29 PM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
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 IPP Rev:J 07-07-28 Added SS Wearplates(Rev E) JLM Verified By:EC
 IPP Rev:K 08-09-23 revF as per dwg DD verified by:ec

Start Qty: 1.00

Required Qty: 1.00

D3490-1



Manufactured No 160 Each 32.0000 4.0000

Cross Bolt Spacer



Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST 32

48277 9

51932 23

D3490-5



Manufactured No 160 Each 55.0000 4.0000

Cross Bolt Spacer



Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST 55

43015 14

46490 41

4 BE 10/02/24

4 BE 10/02/24

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Shop Packet Print

Page 3

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 IPP Rev:K 08-09-23 revF as per dwg DD verified by:ec

Start Qty: 1.00

Required Qty: 1.00

D2743 Manufactured No 220 Each 179.0000 8.0000



Crossbolt Spacer

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
LG	52	
50281	50	
51913	2	
Main Warehouse		
ST	127	
44891	2	
45555	17	
48275	1	
52310	107	

ALS4-1032-225 Purchased No 230 Each 6,296.000 38.0000



Insert

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	6296	
107441	16	
110768 ✓	6280	

8 EC 10/02/24

38. PR 10-3-11

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Shop Packet Print

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Work Order ID: 56276



Parent Item: D350-636-013



Parent Item Name: Skidtube LH

Start Date: 2/18/2010

Required Date: 3/5/2010

Comments: IPP Rev:H 02.09.25 Rearranged procedure steps KJ
 IPP rev I 06.03.30 Per rev. D dwg EC
 IPP Rev:J 07-07-28 Added SS Wearplates(Rev E) JLM Verified By:EC
 IPP Rev:K 08-09-23 revF as per dwg DD verified by:ec

Start Qty: 1.00

Required Qty: 1.00

AN3C5A Purchased No 230 Each 559.0000 34.0000



Bolt

Warehouse	Loc Qty	Loc Code
<u>Location</u>		
Main Warehouse		
ST	559	
111424	8	
111707	69	
112314	1	
113121	201	
113149 ✓	274	
113644	6	

34. Bk 10-3-11

AN3C6A Purchased No 230 Each 766.0000 4.0000



BOLT

Warehouse	Loc Qty	Loc Code
<u>Location</u>		
Main Warehouse		
ST	766	
111982 ✓	766	

2 Bk 10-3-11

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Work Order ID: 56276



Parent Item: D350-636-013



Parent Item Name: Skidtube LH

Start Date: 2/18/2010

Required Date: 3/5/2010

Comments: IPP Rev:H 02.09.25 Rearranged procedure steps KJ
 IPP rev I 06.03.30 Per rev. D dwg EC
 IPP Rev:J 07-07-28 Added SS Wearplates(Rev E) JLM Verified By:EC
 IPP Rev:K 08-09-23 revF as per dwg DD verified by:ec

Start Qty: 1.00

Required Qty: 1.00

AN6C44A Purchased No 230 Each 104.0000 4.0000



BOLT

Warehouse	Loc Qty	Loc Code
Location		
OFFSHORE		
FG	2	
103964	2	
Main Warehouse		
ST	102	
110105	4	
110155	14	
110665	1	
111605	32	
111649	50	
112720	1	

H. 10-3-11

AN8C35A Purchased No 230 Each 128.0000 1.0000



BOLT

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	128	
102180	1	
106896	1	
110105	48	
110847	78	

1 10-3-11

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Work Order ID: 56276



Parent Item: D350-636-013



Parent Item Name: Skidtube LH

Start Date: 2/18/2010

Required Date: 3/5/2010

Comments: IPP Rev:H 02.09.25 Rearranged procedure steps KJ
 IPP rev I 06.03.30 Per rev. D dwg EC
 IPP Rev:J 07-07-28 Added SS Wearplates(Rev E) JLM Verified By:EC
 IPP Rev:K 08-09-23 revF as per dwg DD verified by:ec

Start Qty: 1.00

Required Qty: 1.00

AN960C10L Purchased No 230 Each 388.0000 38.0000



washer

NAS1149C0332R

Warehouse	Loc Qty	Loc Code
Location		
OFFSHORE		
FG 103585	100	
103585	100	
Main Warehouse		
ST	288	
112116	128	
112612	160	

38. 2/10-3-11

AN960C816L Purchased No 230 Each 209.0000 1.0000



WASHER

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	209	
104093	2	
107520	4	
110139	29	
110584	100	
111424 ✓	74	

1 2/10-3-11

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Work Order ID: 56276



Parent Item: D350-636-013



Parent Item Name: Skidtube LH

Start Date: 2/18/2010

Required Date: 3/5/2010

Comments: IPP Rev:H 02.09.25 Rearranged procedure steps KJ
 IPP rev I 06.03.30 Per rev. D dwg EC
 IPP Rev:J 07-07-28 Added SS Wearplates(Rev E) JLM Verified By:EC
 IPP Rev:K 08-09-23 revF as per dwg DD verified by:ec

Start Qty: 1.00

Required Qty: 1.00

D2745 Manufactured No 230 Each 274.0000 8.0000



Bushing

Warehouse	Loc Qty	Loc Code
<u>Location</u>		
Main Warehouse		
ST	36	
43754	2	
44893	33	
45556	1	
Main Warehouse		
ST023	23	
34817	2	
36230	8	
37303	1	
39587	2	
40726	2	
41114	2	
42778	6	
Main Warehouse		
ST46	215	
51537	34	
52311	181	

8. Bl 10-3-11.

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Work Order ID: 56276



Parent Item: D350-636-013



Parent Item Name: Skidtube LH

Start Date: 2/18/2010

Required Date: 3/5/2010

Comments: IPP Rev:H 02.09.25 Rearranged procedure steps KJ
 IPP rev I 06.03.30 Per rev. D dwg EC
 IPP Rev:J 07-07-28 Added SS Wearplates(Rev E) JLM Verified By:EC
 IPP Rev:K 08-09-23 revF as per dwg DD verified by:ec

Start Qty: 1.00

Required Qty: 1.00

D3488-041 Manufactured No 230 Each 9.0000 1.0000



Blade Fitting Assembly, LH

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	9	
47348 ✓	9	

D3492-041 Manufactured No 230 Each 97.0000 8.0000



Plug Assembly

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	97	
51584	20	
55446 ✓	77	

D3492-045 Manufactured No 230 Each 74.0000 8.0000



Plug Assembly

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	74	
51638 ✓	74	

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1 BR 10-3-11

8 BR 10-3-11

8 BR 10-3-11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Work Order ID: 56276



Parent Item: D350-636-013



Parent Item Name: Skidtube LH

Start Date: 2/18/2010

Required Date: 3/5/2010

Comments: IPP Rev:H 02.09.25 Rearranged procedure steps KJ
 IPP rev I 06.03.30 Per rev. D dwg EC
 IPP Rev:J 07-07-28 Added SS Wearplates(Rev E) JLM Verified By:EC
 IPP Rev:K 08-09-23 revF as per dwg DD verified by:ec

Start Qty: 1.00

Required Qty: 1.00

D3535-25 Manufactured No 230 Each 5.0000 1.0000



Wearshoe

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST 52589	5	
	5	

0 BR 10-3-11

D3536-25 Manufactured No 230 Each 30.0000 1.0000



Gasket

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
FP10	25	
54479	25	
Main Warehouse		
ST	5	
45569	1	
47011	2	
47526	2	

1 BR 10-3-11

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Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Work Order ID: 56276



Parent Item: D350-636-013



Parent Item Name: Skidtube LH

Start Date: 2/18/2010

Required Date: 3/5/2010

Comments: IPP Rev:H 02.09.25 Rearranged procedure steps KJ
 IPP rev I 06.03.30 Per rev. D dwg EC
 IPP Rev:J 07-07-28 Added SS Wearplates(Rev E) JLM Verified By:EC
 IPP Rev:K 08-09-23 revF as per dwg DD verified by:ec

Start Qty: 1.00

Required Qty: 1.00

D3537-1 Manufactured No 230 Each 153.0000 3.0000



Wearpad

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
FP	74	
48288	2	
55465 ✓	72	
Main Warehouse		
FP17	79	
51678	1	
51679	78	

3 PR 10-3-11

D3631-1 Manufactured No 230 Each 370.0000 8.0000



Washer

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	370	
52693 ✓	70	
54388	300	

8 PR 10-3-11

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Work Order ID: 56276



Parent Item: D350-636-013



Parent Item Name: Skidtube LH

Start Date: 2/18/2010

Required Date: 3/5/2010

Comments: IPP Rev:H 02.09.25 Rearranged procedure steps KJ
IPP rev I 06.03.30 Per rev. D dwg EC
IPP Rev:J 07-07-28 Added SS Wearplates(Rev E) JLM Verified By:EC
IPP Rev:K 08-09-23 revF as per dwg DD verified by:ec

Start Qty: 1.00

Required Qty: 1.00

D3791-1 Manufactured No 230 Each 14.0000 1.0000



Wearplate

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
FP	12	
55457 ✓	12	
Main Warehouse		
ST	2	
51909	2	

1 BR 10-3-11

D3793-1 Manufactured No 230 Each 11.0000 1.0000



Wearshoe

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	11	
40551	1	
51597 ✓	10	

1 BR 10-3-11

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Work Order ID: 56276



Parent Item: D350-636-013



Parent Item Name: Skidtube LH

Start Date: 2/18/2010

Required Date: 3/5/2010

Comments: IPP Rev:H 02.09.25 Rearranged procedure steps KJ
 IPP rev I 06.03.30 Per rev. D dwg EC
 IPP Rev:J 07-07-28 Added SS Wearplates(Rev E) JLM Verified By:EC
 IPP Rev:K 08-09-23 revF as per dwg DD verified by:cc

Start Qty: 1.00

Required Qty: 1.00

D3793-3 Manufactured No 230 Each 18.0000 1.0000



Wearshoe

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
FP19	11	
55458	11	
Main Warehouse		
ST	7	
51592 ✓	7	

1 BR 10-3-11

D3794-1 Manufactured No 230 Each 18.0000 1.0000



Gasket

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
FP	15	
51928 ✓	3	
55459	12	
Main Warehouse		
ST	3	
46530	1	
47212	2	

1 BR 10-3-11

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Work Order ID: 56276



Parent Item: D350-636-013



Parent Item Name: Skidtube LH

Start Date: 2/18/2010

Required Date: 3/5/2010

Comments: IPP Rev:H 02.09.25 Rearranged procedure steps KJ
 IPP rev I 06.03.30 Per rev. D dwg EC
 IPP Rev:J 07-07-28 Added SS Wearplates(Rev E) JLM Verified By:EC
 IPP Rev:K 08-09-23 revF as per dwg DD verified by:ec

Start Qty: 1.00

Required Qty: 1.00

D3794-3 Manufactured No 230 Each 32.0000 1.0000



Gasket

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
FP	9	
51907 ✓	9	
Main Warehouse		
ST	23	
46531	2	
47440	1	
56066	20	

1 BR 10-3-11

MS21043-6 Purchased No 230 Each 964.0000 4.0000



NUT

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	964	
112314 ✓	964	

4. BR 10-3-11

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Work Order ID: 56276



Parent Item: D350-636-013



Parent Item Name: Skidtube LH

Start Date: 2/18/2010

Required Date: 3/5/2010

Comments: IPP Rev:H 02.09.25 Rearranged procedure steps KJ
 IPP rev I 06.03.30 Per rev. D dwg EC
 IPP Rev:J 07-07-28 Added SS Wearplates(Rev E) JLM Verified By:EC
 IPP Rev:K 08-09-23 revF as per dwg DD verified by:ec

Start Qty: 1.00

Required Qty: 1.00

MS21083C8 Purchased No 230 Each 72.0000 1.0000



NUT

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	72	
110584	5	
111424	2	
113149 ✓	15	
113845	50	

1 BR 10-3-11

NAS1611-040 Purchased No 230 Each 322.0000 1.0000



O-RING

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	322	
110715	44	
110915	278	

PTO →

* O'Ring
 NAS 1611-005

106 O'Ring

8. BR 10-3-11

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
10-3-11	230	NAS1611-010 CHANGE FOR 02594-3 (55646)	BR	10-3-11	8		8 10/03/16

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Work Order ID: 56276



Parent Item: D350-636-013



Parent Item Name: Skidtube LH

Start Date: 2/18/2010

Required Date: 3/5/2010

Comments: IPP Rev:H 02.09.25 Rearranged procedure steps KJ
 IPP rev I 06.03.30 Per rev. D dwg EC
 IPP Rev:J 07-07-28 Added SS Wearplates(Rev E) JLM Verified By:EC
 IPP Rev:K 08-09-23 revF as per dwg DD verified by:ec

Start Qty: 1.00

Required Qty: 1.00

AN8C21A Purchased No 260 Each 126.0000 2.0000



BOLT

10-3-12 SP

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	126	
105160	1	
107596	1	
107924	2	
109092	2	
110341	2	
110342	2	
111605	50	
112720	16	
113558	50	

AN960C816L Purchased No 260 Each 209.0000 2.0000



WASHER

10-3-12 SP

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	209	
104093	2	
107520	4	
110139	29	
110584	100	
111424	74	

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Work Order ID: 56276



Parent Item: D350-636-013



Parent Item Name: Skidtube LH

Start Date: 2/18/2010

Required Date: 3/5/2010

Comments: IPP Rev:H 02.09.25 Rearranged procedure steps KJ
 IPP rev I 06.03.30 Per rev. D dwg EC
 IPP Rev:J 07-07-28 Added SS Wearplates(Rev E) JLM Verified By:EC
 IPP Rev:K 08-09-23 revF as per dwg DD verified by:ec

Start Qty: 1.00

Required Qty: 1.00

D2741 Manufactured No 260 Each 22.0000 1.0000



Blade, 350 Skidtube

10-3-12 SP

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

22

51931

22

230

260

Each

1,700.000 4.0000



D3672-1



Phenolic Washer

Manufactured No

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

1200

39275

19

42329

5

47628

176

52505

1000

Main Warehouse

ST117

500

51674

500

PTD

BL 10-3-11.

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
100311	230	permanent change - change seq TO 230	NA	10.03.24		U	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Work Order ID: 56276

Parent Item: D350-636-013

Parent Item Name: Skidtube LH

Comments: IPP Rev:H 02.09.25 ☐ Rearranged procedure steps ☐ KJ ☐
 IPP rev I 06.03.30 Per rev. D dwg EC
 IPP Rev:J 07-07-28 Added SS Wearplates(Rev E) JLM Verified By:EC
 IPP Rev:K 08-09-23 revF as per dwg DD verified by:ec

Start Date: 2/18/2010

Required Date: 3/5/2010

Start Qty: 1.00

Required Qty: 1.00

D3672-13

Phenolic Washer

Purchased No 260 Each 930.0000 2.0000

Warehouse
Location

Main Warehouse
 ST

Loc Qty

Loc Code

930

930

54363

Purchased No

260 Each

72.0000 2.0000

MS21083C8

NUT

Warehouse
Location

Main Warehouse
 ST

Loc Qty

Loc Code

72

5

2

15

50

110584

111424

113149

113845

10-3-12 SF

2

10-3-12 SF (15)

2

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

QTY -041	QTY -042	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
X				D2750-041	350 SKIDTUBE ASSEMBLY, LH
	X			D2750-042	350 SKIDTUBE ASSEMBLY, RH
		X		D2750-043	350 SKIDTUBE ASSEMBLY, LH
			X	D2750-044	350 SKIDTUBE ASSEMBLY, RH
1	1	1	1	D2739	WEB
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1				D2750-1	SKIDTUBE WELDMENT, LH
	1			D2750-2	SKIDTUBE WELDMENT, RH
		1		D2750-3	SKIDTUBE WELDMENT, LH
			1	D2750-4	SKIDTUBE WELDMENT, RH
1		1		D3488-041	BLADE FITTING, LH
	1		1	D3488-042	BLADE FITTING, RH
4	4	4	4	D3490-1	SPACER
4	4			D3490-3	SPACER
		4	4	D3490-5	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
8	8			D3492-043	PLUG ASSEMBLY
		8	8	D3492-045	PLUG ASSEMBLY
1	1	1	1	D3535-25	WEARSHOE
1	1	1	1	D3536-25	GASKET
3	3	3	3	D3537-1	WEARPAD
8	8	8	8	D3631-1	WASHER
1	1	1	1	D3791-1	WEARPLATE
1	1	1	1	D3793-1	WEARSHOE
1	1	1	1	D3793-3	WEARSHOE
1	1	1	1	D3794-1	GASKET
1	1	1	1	D3794-3	GASKET
38	38	38	38	ALS4-1032-225	INSERT (OR ALS7-1032-225, AKS4-1032-225, AELS-1032-225)
34	34	34	34	AN3C5A	BOLT
4	4	4	4	AN3C6A	BOLT
4	4	4	4	AN6C44A	BOLT
1	1	1	1	AN8C35A	BOLT
38	38	38	38	AN960C10L	WASHER
1	1	1	1	AN960C816L	WASHER
4	4	4	4	MS21043-6	NUT
1	1	1	1	MS21083C8	NUT
4	4	4	4	NAS1515H3L	WASHER

GENERAL NOTES:

- MATERIAL: MAKE D2750-1/-2/-3/-4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
- FINISH: ACID ETCH, ALONDE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB. POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3. BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
- TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- UNITS: INCHES UNLESS OTHERWISE NOTED
- BREAK SHARP EDGES: N/A
- IDENTIFICATION: N/A
- WEIGHT: D2750-041/-042/-043/-044 = 26.5 LBS
- WELD PER DART QSI 004
- INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED. DRILL 'F' SIZE HOLES ($\phi 0.297$) FOR WEARSHOE INSERTS
- FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:
MINIMUM YIELD TENSILE STRENGTH = 35 KSI
MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
- SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY. CLEAN EXCESS OFF
- POWDER COATING WITH MEK DEGREASER.
- SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL
- SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

#56276

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F	INCORPORATE DSI 9413: QTY (3) D3537-1 WAS QTY (5) (ZN C8-1); D3791-1/-3 REPLACES D3535-13/-35 (ZN C8-1); D3794-1/-3 REPLACES D3536-13/-35 (ZN B8-1); ADD D3791-1 (ZN C8-1); WEARSHOE HOLES UNDER FWDRAFT SADDLE REMOVED (8 PL). WEARSHOE HARDWARE QTY UPDATED (ZN B8-1); D3488-041/-042 HARDWARE UPDATED (ZN C1-8, 9, 10, 11); ADD NOTE 12 AND 13 (ZN A5-1); REASON: REF. NCR 05-043	PH	08.07.16
E	CHANGE TO STAINLESS STEEL WEARPLATES; ADD RUBBER GASKETS, CHANGE INSERTS; ADD D3631-1; REMOVE QTY (38) NAS1515H3L, REMOVE QTY (10) NAS1515H3L, REMOVE D2741, QTY (2) AN960C816, REMOVE QTY (2) MS21083C8	CB	07.05.17
D	ADD HOLES AND SPACERS FOR APICAL FLOATS; INCORPORATE DEO 9133/9157	PH	06.01.05
C	ADD D2750-3/D2750-4; INCORPORATE D2738 AND D2740	CP	98.11.18
B	CHANGE MS24694-S293 TO AN8-15A	CP	98.09.01
A	NEW ISSUE	DS	98.04.16
REV	DESCRIPTION	BY	DATE
DESIGN	PORT		
DRAWN	PORT		
CHECKED	PORT		
MFG. APPR.	PORT		
APPROVED	PORT		
DE APPR.	PORT		
DATE	08.07.16		

DART AEROSPACE USA, INC.
PORT HADLOCK, WA

DRAWING NO.
D2750
TITLE
350 SKIDTUBE ASSEMBLY
SCALE
NTS

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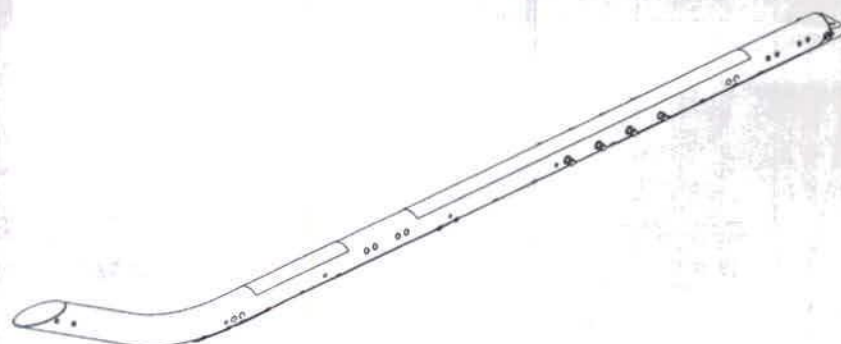
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

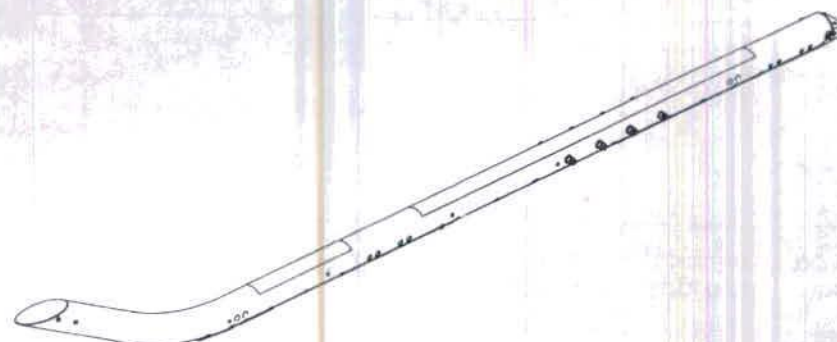
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NOTE: Date & initial all entries

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D2750-043 350 SKIDTUBE ASSEMBLY, LH



D2750-044 350 SKIDTUBE ASSEMBLY, RH

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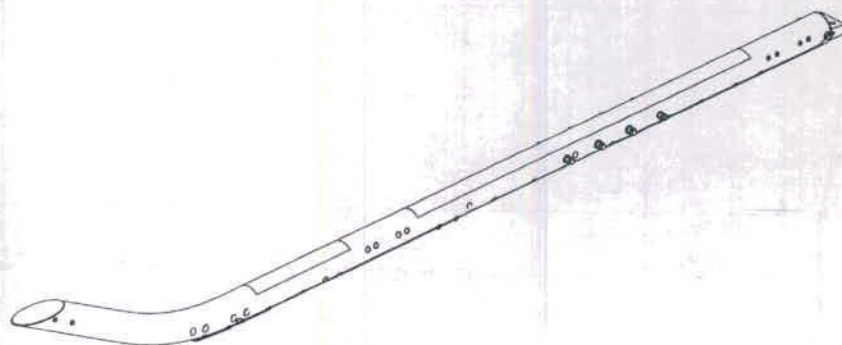
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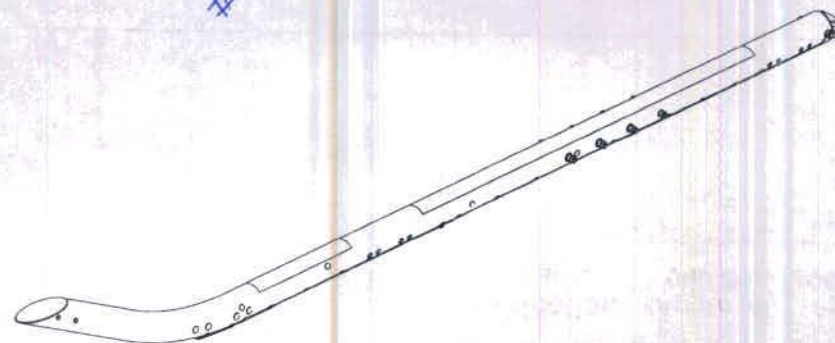
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D2750-041 350 SKIDTUBE ASSEMBLY, LH



D2750-042 350 SKIDTUBE ASSEMBLY, RH

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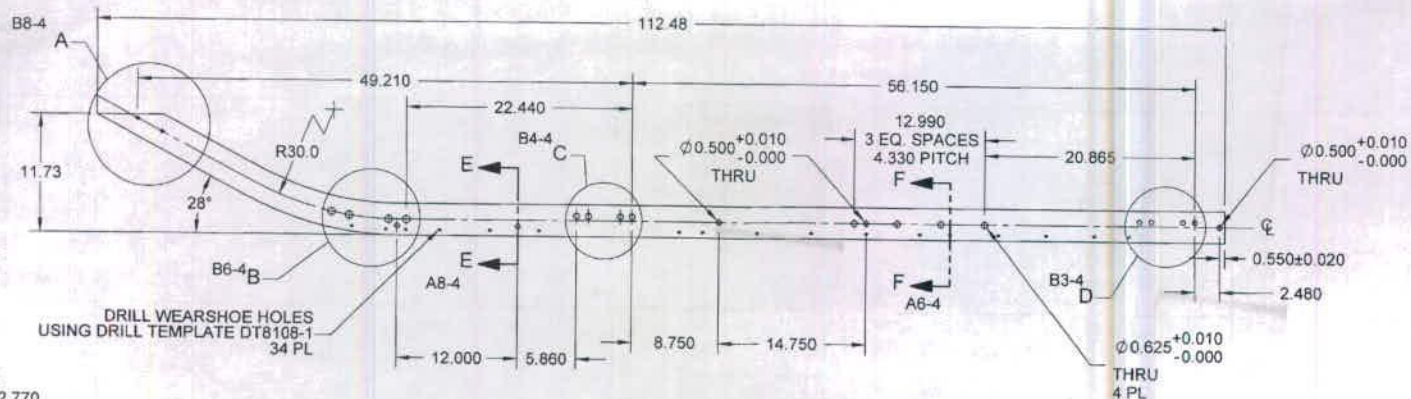
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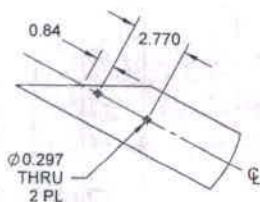
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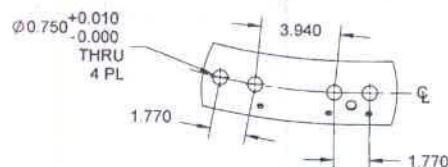
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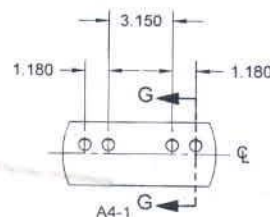
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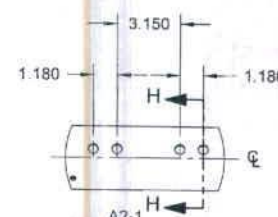
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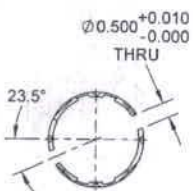
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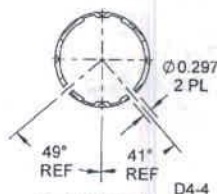
DETAIL C
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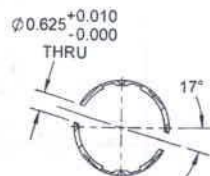
DETAIL D
SCALE 2X



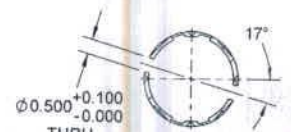
SECTION E-E
SCALE 3X, 2 PL



SECTION F-F
SCALE 3X, 17 PL



SECTION G-G
SCALE 3X, 4 PL



SECTION H-H
SCALE 3X, 4 PL

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DART AEROSPACE USA, INC.
PORT HADLOCK, WA

DRAWING NO. **D2750** REV. F
TITLE **350 SKIDTUBE ASSEMBLY** SCALE NTS

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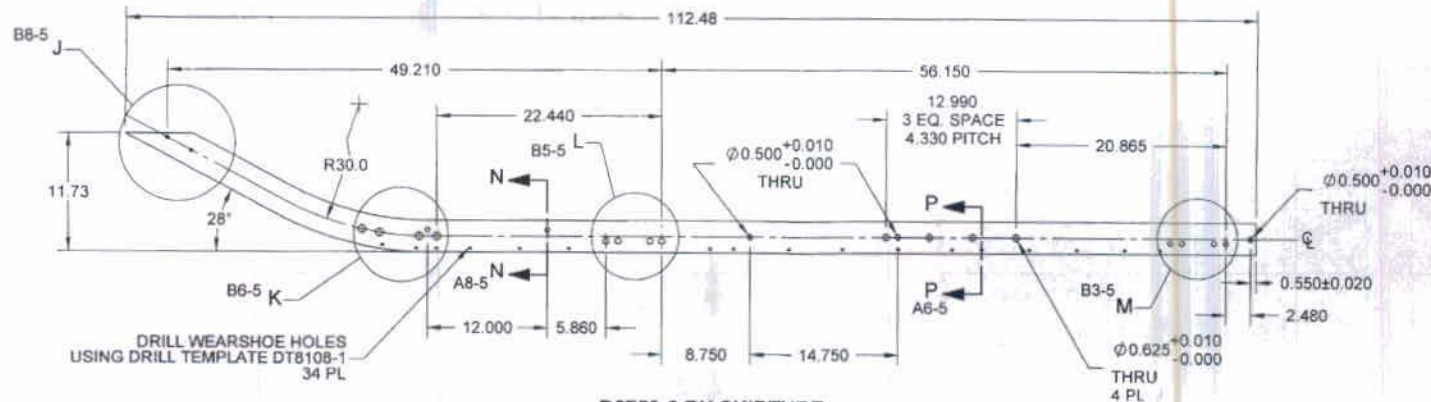
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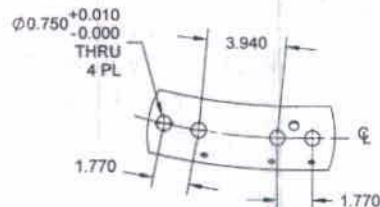
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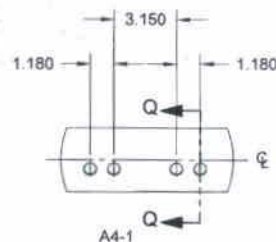
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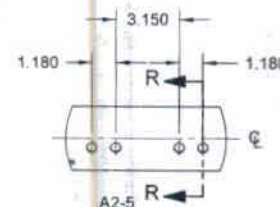
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SCALE 2X



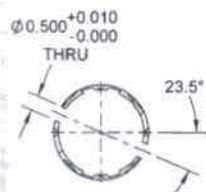
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SCALE 2X



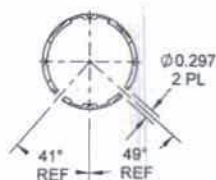
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SCALE 2X



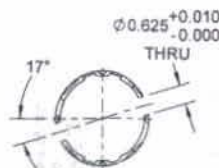
DETAIL M
SCALE 2X



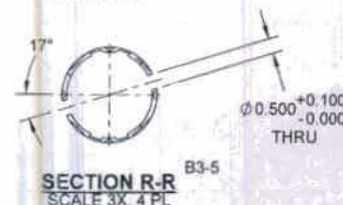
SECTION N-N
SCALE 3X, 2 PL



SECTION P-P
SCALE 3X, 17 PL



SECTION Q-Q
SCALE 3X, 4 PL



SECTION R-R
SCALE 3X, 4 PL

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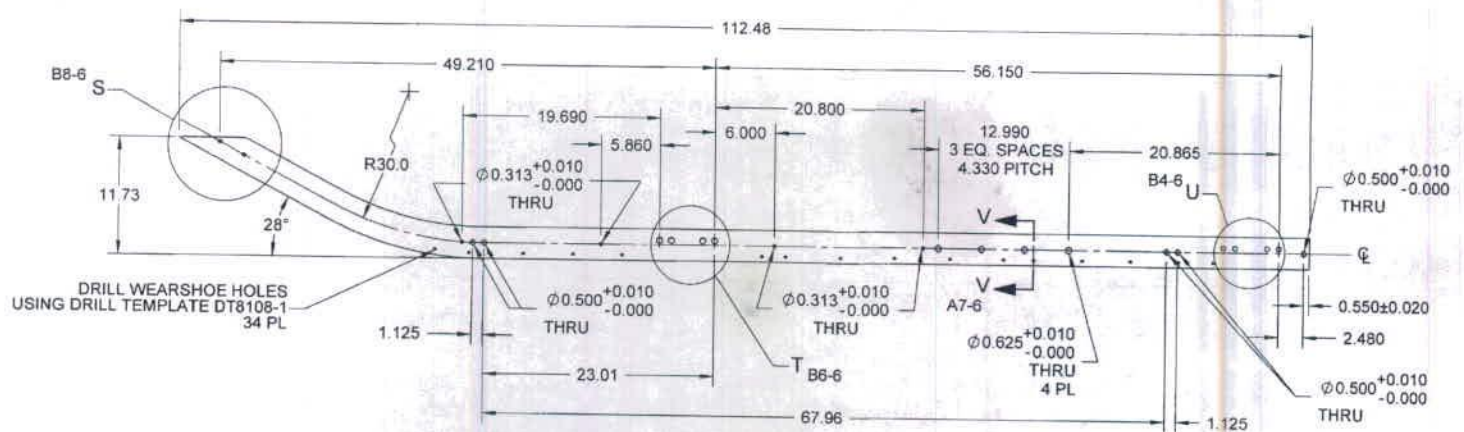
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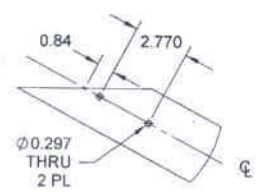
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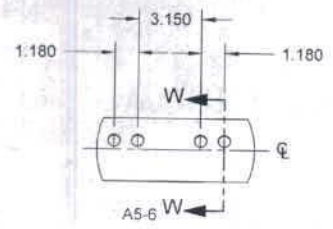
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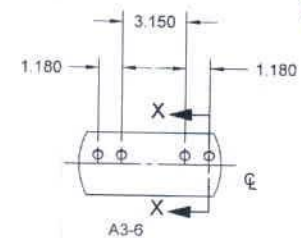
D2750-3 LH SKIDTUBE



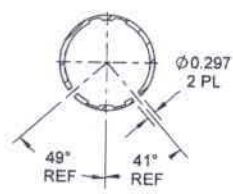
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D8-6
SCALE 2X



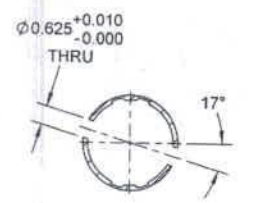
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C5-6
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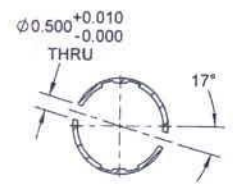
DETAIL U
D3-6
SCALE 2X



SECTION V-V
C4-6
SCALE 3X, 17 PL



SECTION W-W
B6-6
SCALE 3X, 4 PL



SECTION X-X
B4-6
SCALE 3X, 4 PL

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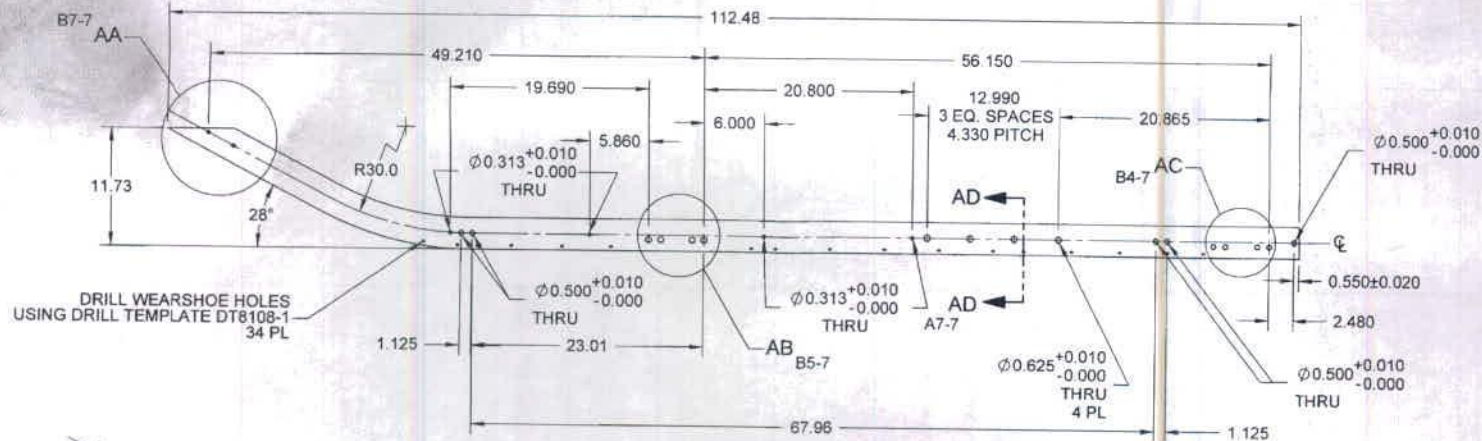
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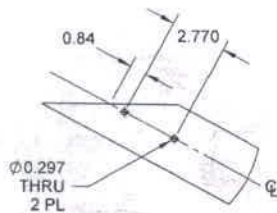
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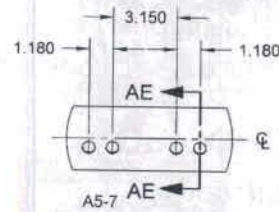
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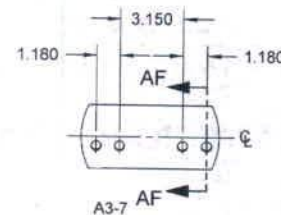
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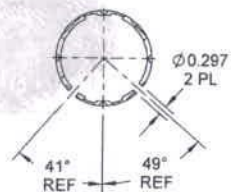
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SCALE 2X



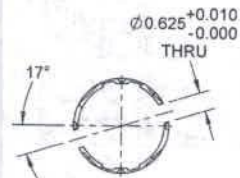
DETAIL AB
SCALE 2X



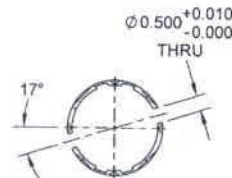
DETAIL AC
SCALE 2X



SECTION AD-AD
SCALE 3X, 17 PL



SECTION AE-AE
SCALE 3X, 4 PL



SECTION AF-AF
SCALE 3X, 4 PL

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08-09-2014

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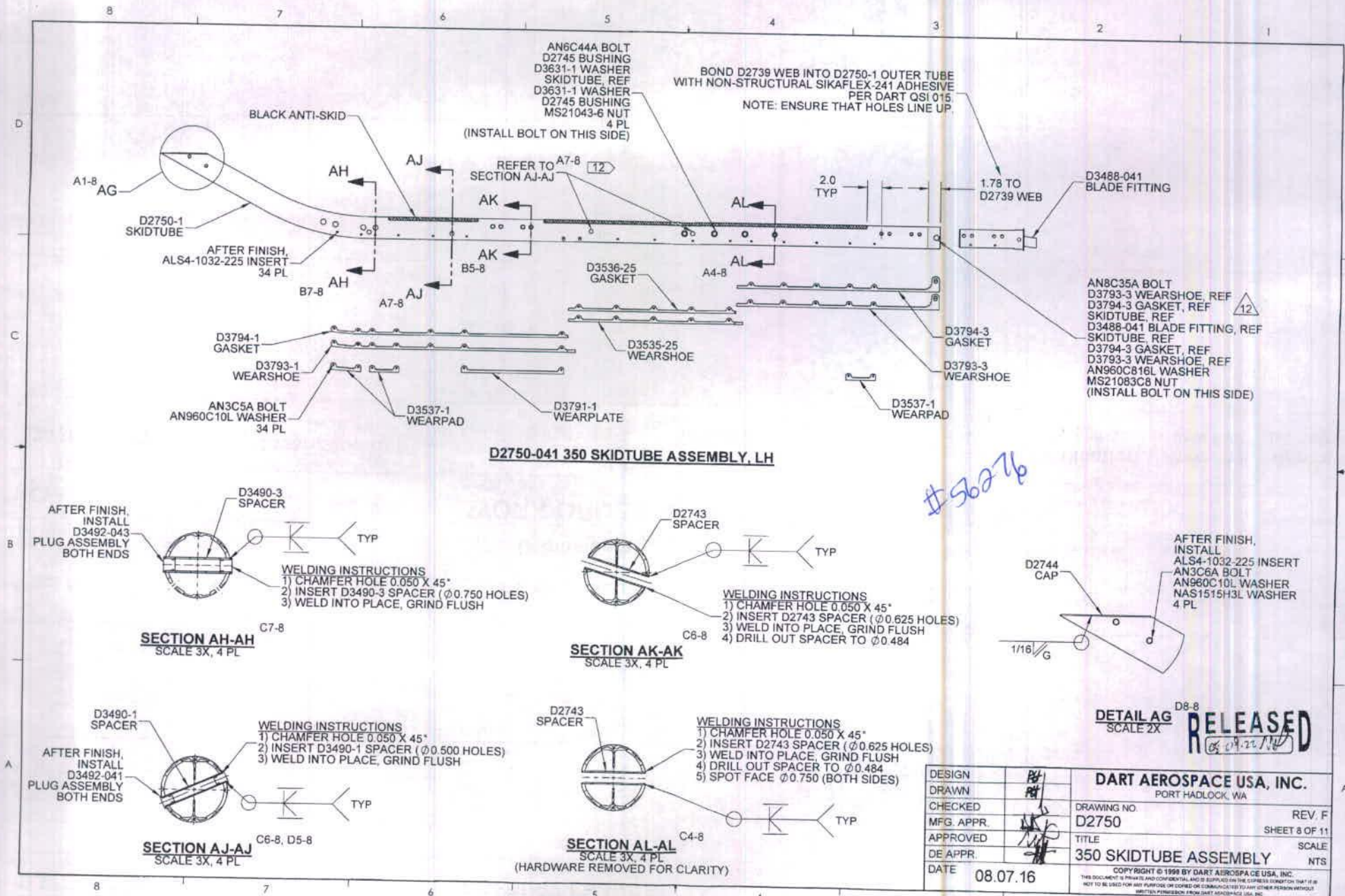
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



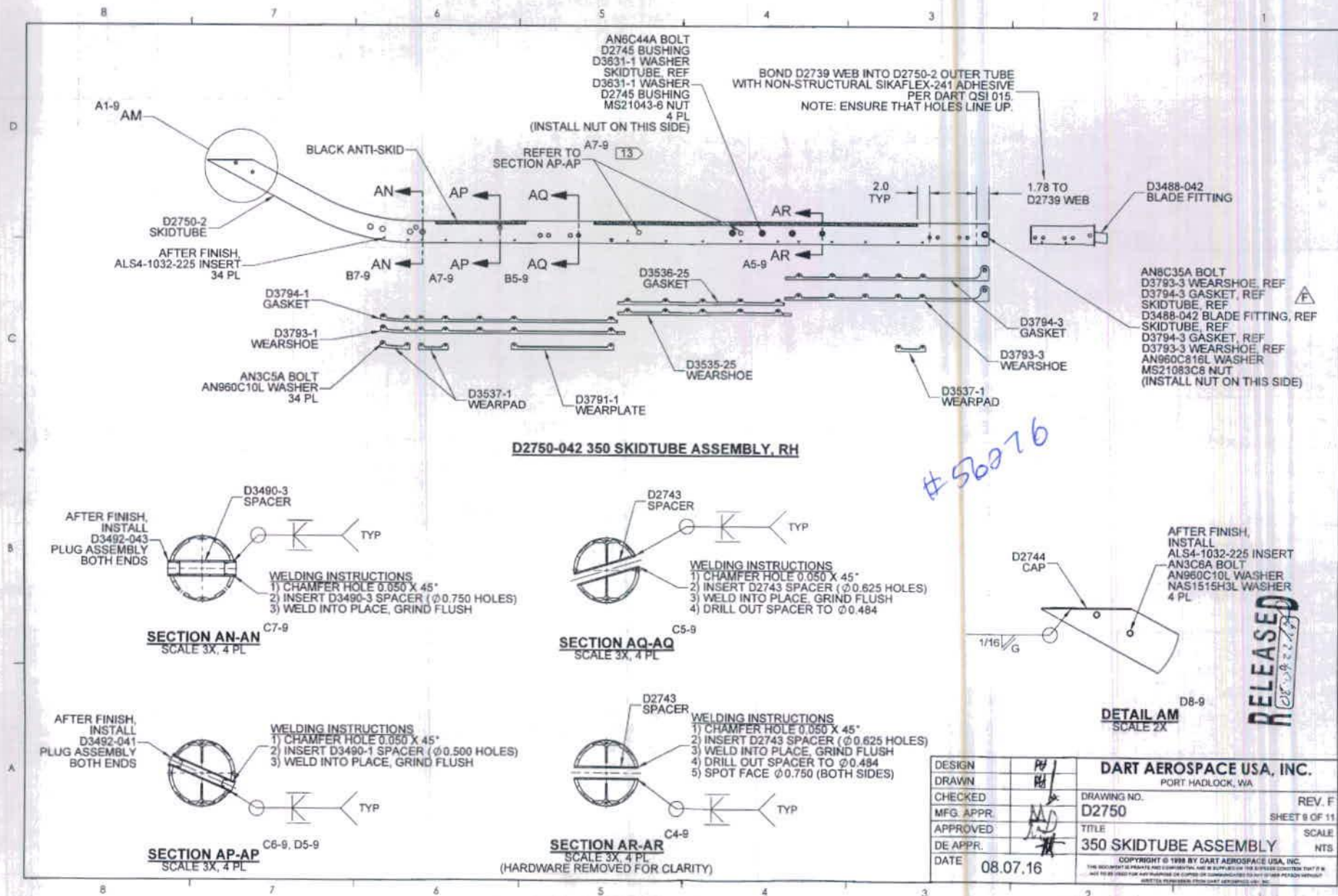
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



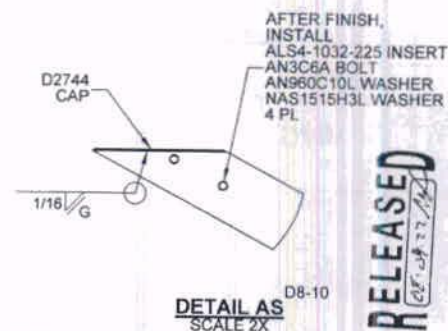
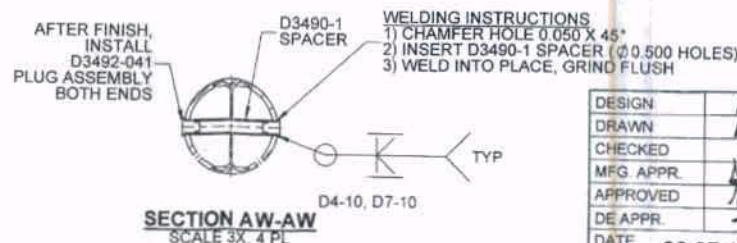
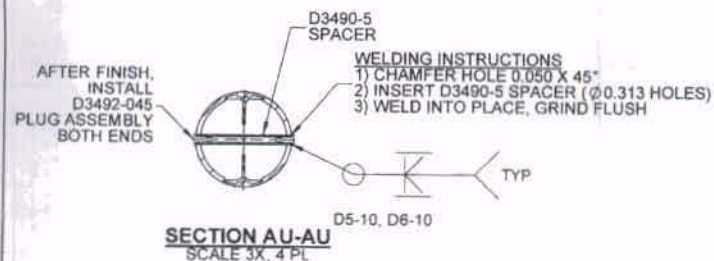
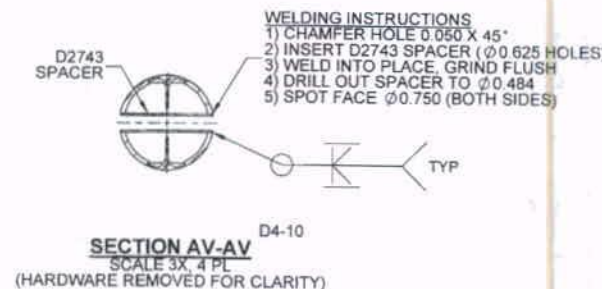
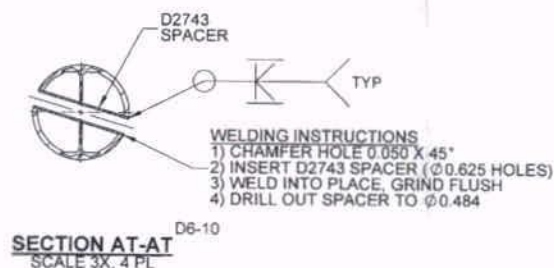
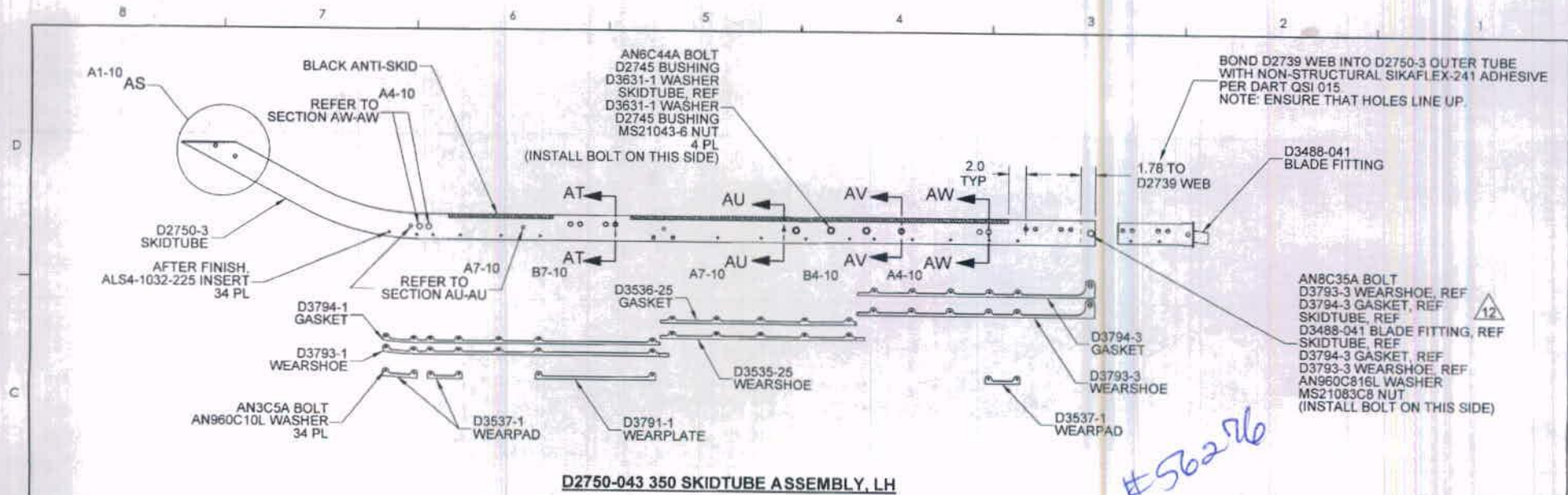
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN	RE	DART AEROSPACE USA, INC.	
DRAWN	RE	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG APPR.		D2750	SHEET 10 OF 11
APPROVED		TITLE	SCALE
DE APPR.		350 SKIDTUBE ASSEMBLY	NTS
DATE		COPYRIGHT © 1986 BY DART AEROSPACE USA, INC.	
08.07.16		THIS DOCUMENT IS PREPARED AND CONTAINS UNCLASSIFIED INFORMATION. IT IS THE PROPERTY OF DART AEROSPACE USA, INC. AND IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY FORM OR BY ANY MEANS WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

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SEP 27 1986

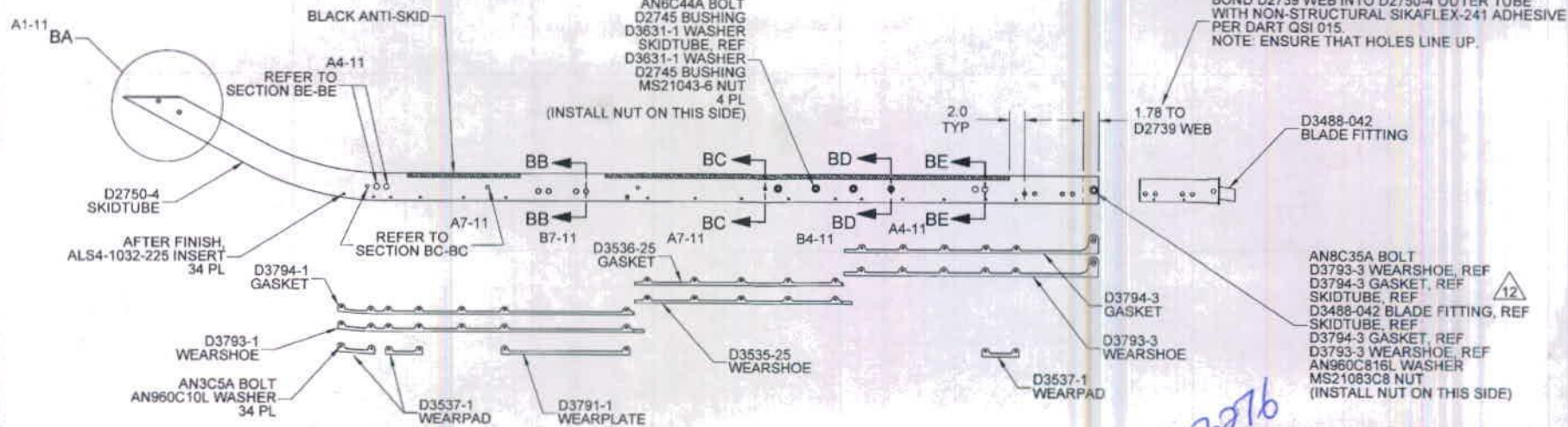
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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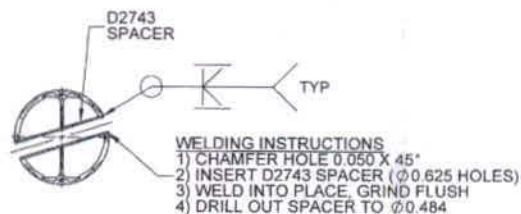
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D2750-044 350 SKIDTUBE ASSEMBLY, RH



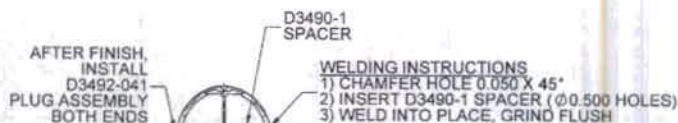
SECTION BB-BB
SCALE 3X, 4 PL



SECTION BD-BD
SCALE 3X, 4 PL
(HARDWARE REMOVED FOR CLARITY)



SECTION BC-BC
SCALE 3X, 4 PL



SECTION BE-BE
SCALE 3X, 4 PL

RELEASED
06 07 22 / 10P



DETAIL BA
SCALE 2X

DESIGN	14	DART AEROSPACE USA, INC.	
DRAWN	14	PORT HADLOCK, WA	
CHECKED	14	DRAWING NO.	REV. F
MFG APPR.	14	D2750	SHEET 11 OF 11
APPROVED	14	TITLE	SCALE
DE APPR.	14	350 SKIDTUBE ASSEMBLY	NTS
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

NO. 225

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliott
Job number: 5276
Part number: D350-62-013
Description: 350 skid tube
Welding Process: Tig[☒] Mig[]
Base material: Aluminium
Current: AC[☒] DC[]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[]
Penetration: pass[☒] fail[]

UNACCEPTABLE

Cracks: pass[☒] fail[]
Undercut: pass[☒] fail[]
Pin holes: pass[☒] fail[]
Overlap (cold lap): pass[☒] fail[]
Porosity (surface): pass[☒] fail[]
Coloration: pass[☒] fail[]

Qualifier Pat. D. J. Date of Test Coupon 10.02.19

Welder Barclay Elliott Date of Test Coupon 16.02.19

The above named individual is qualified in accordance with AWS D17.1.2001 to weld

